

Date: Wednesday, 09/04/2008 9:18:32 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: PANEL-350 FWD CANOPY		
Job Number	: 38506 -1			Part Number	: D36563		
Estimate Number	: 13099			Drawing Number	: D3656 REV A		
P.O. Number	:			Project Number	: 00204		
This Issue	: 09/04/2008	S.O. No.	:	Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: THERMOFORMING	Due Date	: 30/04/2008	Qty:	2 Um: Each
Previous Run	: 37666						
Written By	:						
Checked & Approved By	: JD 08.4.09						
Comment	: Est. Rev. A 07/12/13 DL verified by DD						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET	ATC
		Comment: Qty.: 23.0000 sf(s)/Unit Total : 46.0000 sf(s) GE PLASTICS LEXAN SHEET batch: M107574	X6 → BB 08/09/10 X6
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING	
		Comment: HAND FINISHING THERMOFORMING	BB 08/09/10 X6
	1) Cut Blanks to fit frame size		BB 08/09/10 X6
3.0	THERMOFORMING	THERMOFORMING MACHINE	
		Comment: THERMOFORMING MACHINE	X6 -
		Thermoform as per Dwg. D3656-3 and Folio FTA 016 using tool DT8987	BB 08/09/10 X6
	Dwg. Rev. <u>A</u>	Folio Rev. <u>A</u>	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	PTO.
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	X6 - (X6)
		Visually inspect for proper formation of each part	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.04.10	1	Change material usage to 34.66 sq. ft to remove leftover unusable material from stock. (correct estimate)			D	08.04.10		08.09.17	08.09.17

Part No: D3656-3 PAR #: N/A Fault Category: Pod Thermforming NCR: Yes No DQA: D Date: 08/09/17
 D350-766-013. QA: N/C Closed: D Date: 08/09/17

NCR: 38506		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.04.10	4.	Parts did not form. x4 webbing.	D	Scrap & destroy Qty 4 Modify tool to control webbing Work in process	W 08.04.10			
08.04.10	5.	R.C: too much material in one spot, on the 2nd corners of the mold.				08.04.24	DS/ALL	08.04.24

NOTE: Date & initial all entries

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Drawing Name: PANEL-350 FWD CANOPY

Job Number: 38506

Part Number: D36563

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 QC8



SECOND CHECK

08/04/11
JL

Comment: SECOND CHECK

6.0 HAND FINISH TH



HAND FINISHING THERMOFORMING

08/04/11
JL

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions as per dwg D36563

7.0 QC2



INSPECT PARTS AS THEY COME OFF MACHINE

08/04/11
JL

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

8.0 QC5



INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/11 (x2)

9.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

P 08/04/11 (x2)

10.0 QC21



FINAL INSPECTION/W/O RELEASE



08/09/11 (x2)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



cmf 08-09-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	WORK ORDER:	38506
Description: PANEL 350 FWD CANOPY	Part Number:	D36563
Inspection Dwg: D3656 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

(Step 4) Thermoforming Visual Inspection Sign-off

Description	Initials
Tight, even radius throughout part	DH
Acceptable shape definition	DH
Acceptable texture retention	DH
Free of visual flaws (bumps, cracks, voids, etc.)	DH

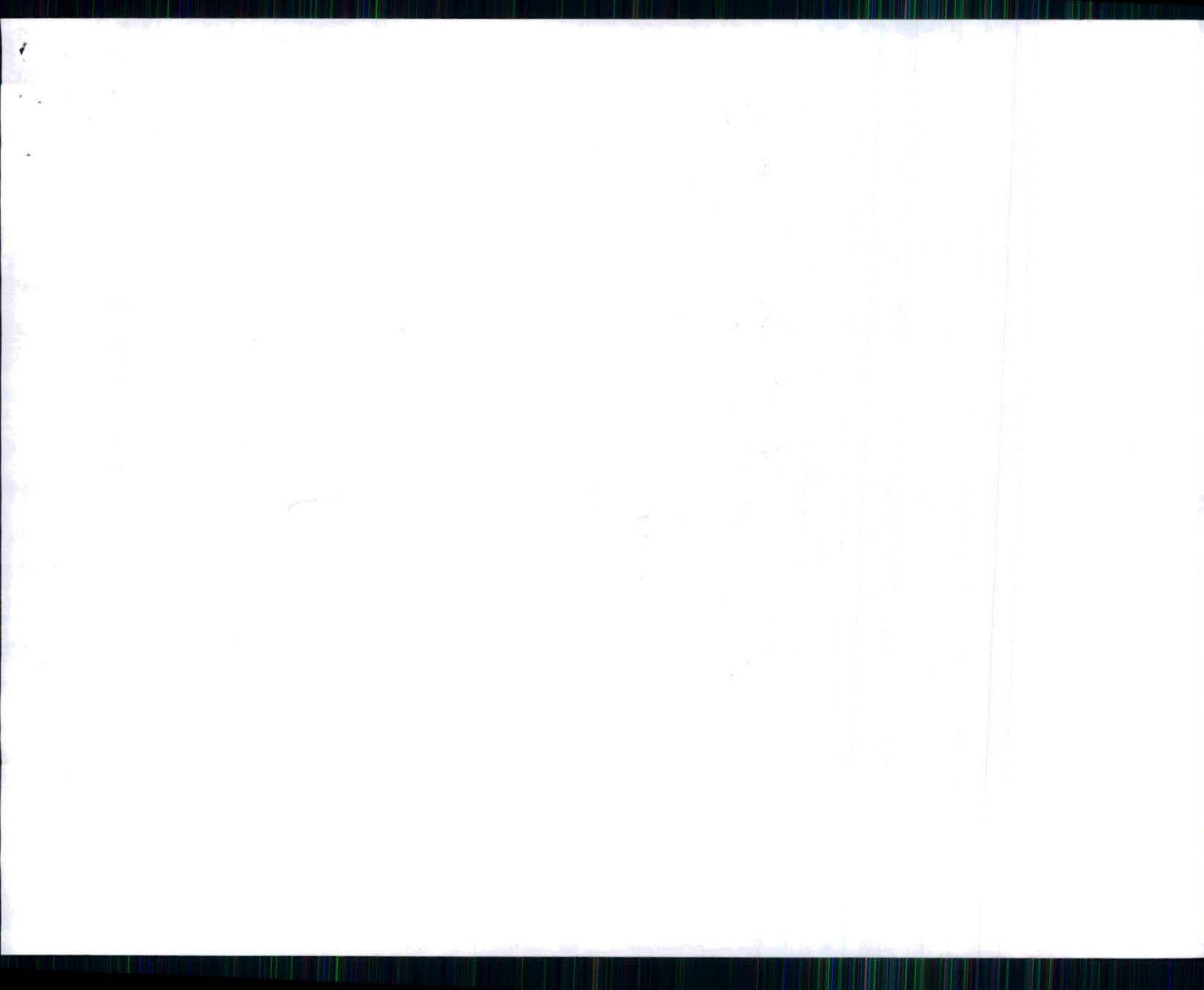
(Step 6) Trimming FAI Checklist

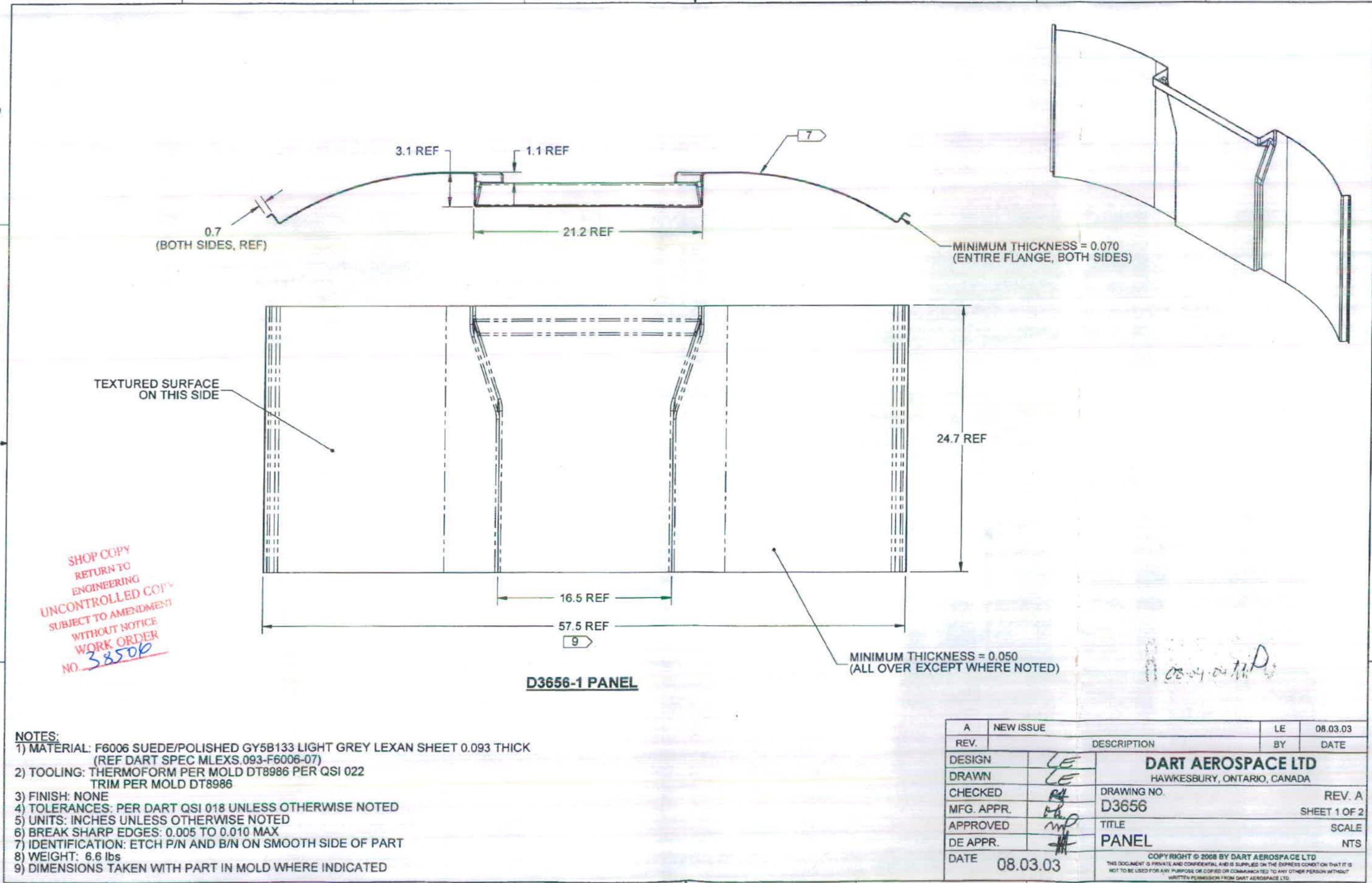
Inspect dimensions highlighted on inspection sheet drawing 036563 Rev. A and record below

Measured by:	<u>Dh</u>	Audited by:	<u>H</u>	Prototype Approval:	<u>MD</u>
Date:	<u>08-04-10</u>	Date:	<u>08-04-24</u>	Date:	<u>08-04-10</u>

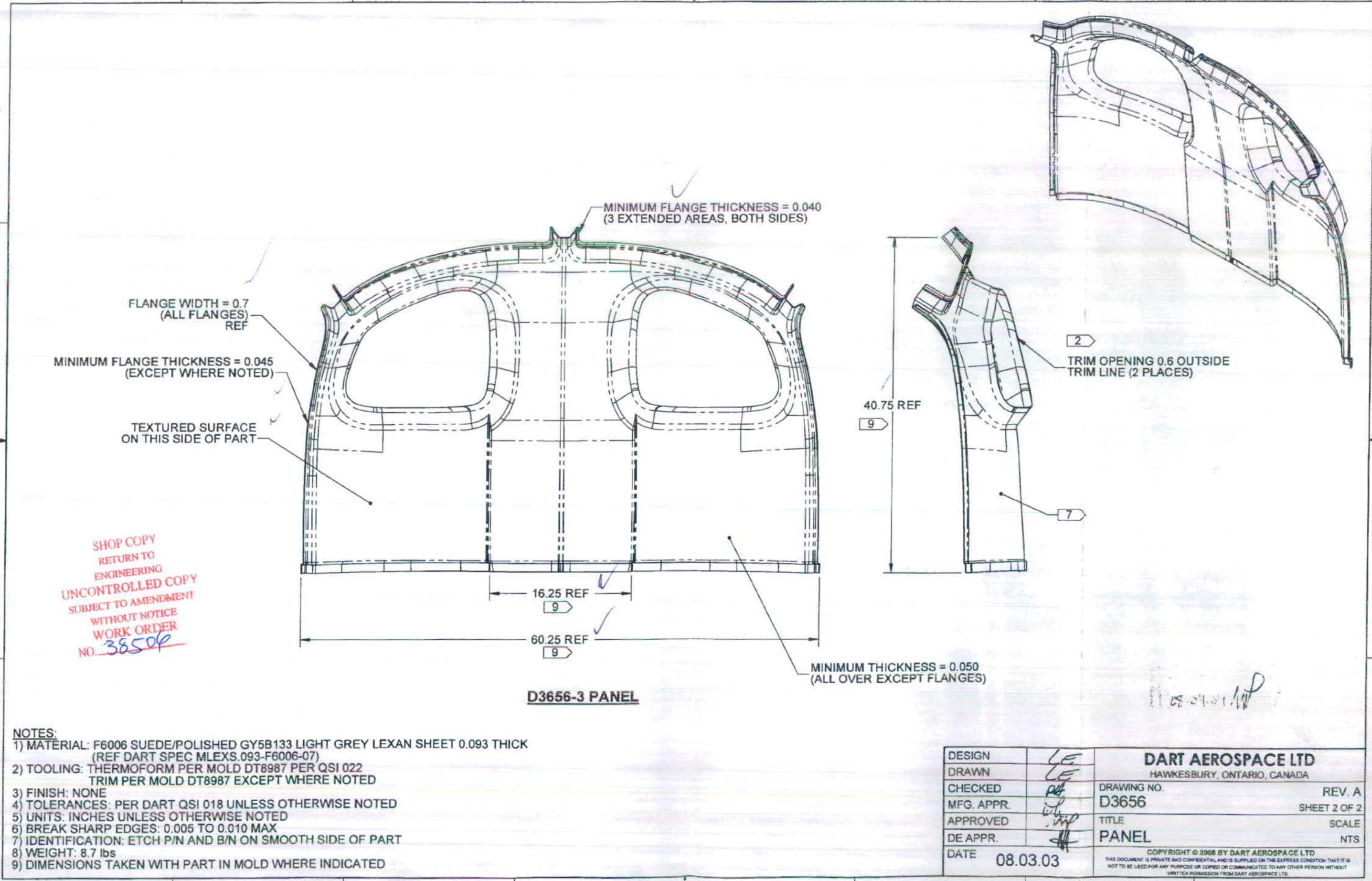
Rev	Date	Change	Revised by	Approved
		New Issue		

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DESIGN	LE	DART AEROSPACE LTD
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA
CHECKED	PS	DRAWING NO.
MFG. APPR.	WJ	D3656
APPROVED	WJ	REV. A
DE APPR.	WJ	SHEET 2 OF 2
DATE	08.03.03	SCALE
		NTS

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W. T. B.
1940
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Dad
1940
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W. T. B.